

Date: Tuesday, 5/23/2006 11:36:23 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FOLDING STEP WELDMENT RH
<b>Job Number</b> :	27220		
<b>Estimate Number</b> :	10697		
<b>P.O. Number</b> :	NIA	<b>Part Number</b> :	D3388042
<b>This Issue</b> :	5/23/2006	<b>S.O. No.</b> :	NIA
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3388 REV A
<b>First Issue</b> :	NIA	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27087	<b>Drawing Revision</b> :	A
		<b>Material</b> :	NIA
<b>Written By</b> :	<i>[Signature]</i>	<b>Due Date</b> :	6/15/2006
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i> 06.05.23	<b>Qty:</b>	4
<b>Comment</b> :	Est. B 06.06.10 Added Step 11 KJ/JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

D2622-120C extrusion

Batch: 327077

*SE. 06.05.31 = 4*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

CUT D2622-120C extrusion 85.15" long as per Dwg D3388

Deburr and bevel ends for welding

*SE. 06.05.31 = 4*

3.0	D2734	206 Step Endplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	324402

*SE. 06.05.31 = 4*

4.0	D33872	Arm
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	327105 = 4

327143 = 4

*SE. 06.05.31 = 4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 11:36:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27220

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and (1) end cap as per Dwg D3388.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: M19173 M15689

PC 06.05.31  
FF 06.06.01

4  
4

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.06.02

20.06.03 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.06.05 4

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld last end cap as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: M15689

PC 06.06.12 4

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

20.06.21 (4)

PC 06.06.13 (4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

PC 06.06.25 (4)

11.0

POWDER COATING

POWDER COATING


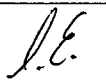
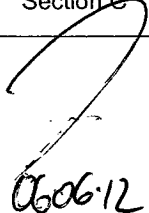
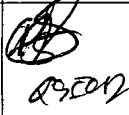
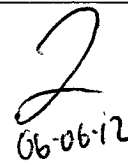


Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-12	8	tiny piece of weld fell inside of step during welding.		open hole in cap as necessary to remove foreign object. and fill hole with weld; grind flush as per asl out.	 06-06-12	 06-06-12		 06-06-12

Part No: D3388-042 PAR #: N/A Fault Category: Prod. lg. F&B NCR: ☒ Yes ☐ No DQA: HA Date: 06-08-23  
 NOTE: Date & initial all entries QA: N/C Closed: HA Date: 06-08-23

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27220

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

SC 06/07/18

(4)

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

06-08-01 (4)

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808 Spacer

227 564

Press spacer into D3387-2 arm as per Dwg D3387

SAD 06:08:01

(4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-01 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

USA

8B 06/08/07

(4)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-08-23

Job Completion



CLO 06/08/02

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

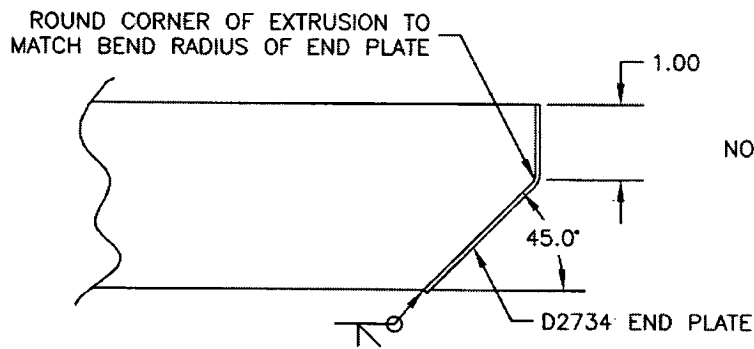
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

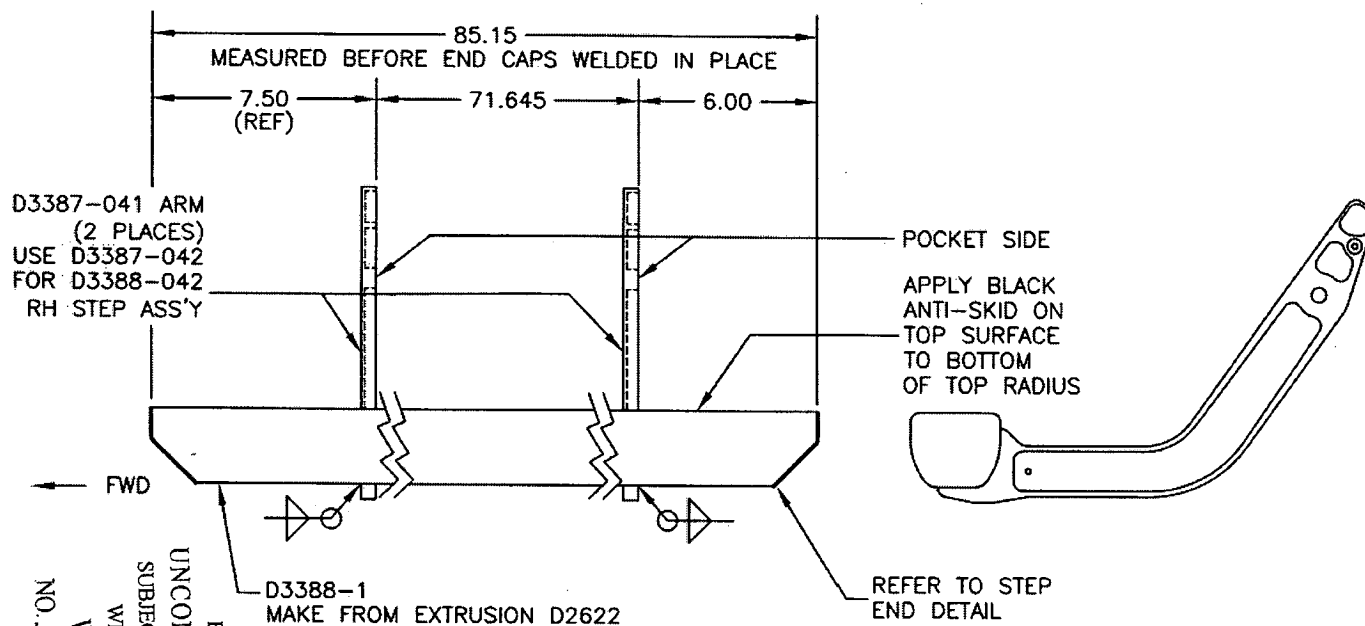
RELEASED

05.03.11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL  
NOT TO SCALE



**D3388-041 LH STEP ASSEMBLY (SHOWN)**  
**D3388-042 RH STEP ASSEMBLY (OPPOSITE)**

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 27220

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DART AEROSPACE LTD
05.01.20	05.01.20	NEW ISSUE
CHECKED	APPROVED	DRAWING NO. D3388
DATE	TITLE	STEP WELDMENT
05.01.20	SCALE	NTS

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_